

Date: Thursday, 13/12/2007 9:56:28 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : PROTO

PROTOTYPE

Job Number : 36315

Estimate Number : 13098

P.O. Number :

Part Number : D36561

This Issue : 13/12/2007 S.O. No. :

Drawing Number : D36561

Prsht Rev. : NC

Project Number : 00204

First Issue : // Type : THERMOFORMING

Drawing Revision : A

Previous Run :

Material :

Written By :

Due Date : 21/12/2007

Qty: 1 Um: Each

Checked &amp; Approved By :

Comment : Est. Rev. A 07/12/13 DL

## Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0 ~~F60029~~ MLEX5093F600607 lexan grey

Comment: Qty.: 23.0000 sf(s)/Unit Total : 46.0000 sf(s)  
 lexan grey BATCH M105494

2.0 HAND FINISH TH

HAND FINISHING THERMOFORMING

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

3.0 THERMOFORMING

THERMOFORMING MACHINE

Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-1 and Folio FTA 015

Dwg. Rev. A

Folio Rev. A

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8

SECOND CHECK

Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/12/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/13	1	WRONG MAT. LISTED ON ESTIMATE & W.O.	VE 07.12.13	USE #MCEXSF600607	VE 07.12.13		VE 07.12.13	<u>07.12.19</u>
07/12/13	9	FOR USE IN R+D ONLY.	VE 07.12.18	NO PACKAGING	VE 07.12.18		VE 07.12.18	<u>07.12.19</u>

NOTE: Date & initial all entries

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Drawing Name: PROTO

Job Number: 36315

Part Number: D36561

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Sh 07/12/13

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

N/A -> prototype

Sh 10/12/13

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sh 12-19-10  
Fit is good.

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

N/A

PTO ->

N/A.

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Sh 07/12/10  
00204

Job Completion



Sh 07/12/10

# **PROTOTYPE REQUEST FORM**

DART Aerospace Ltd.

Product #: D350-766

Job #: 00204

Date: 07.12.12

Product Name: INTERIOR TRIM KITS

Requested By: LE

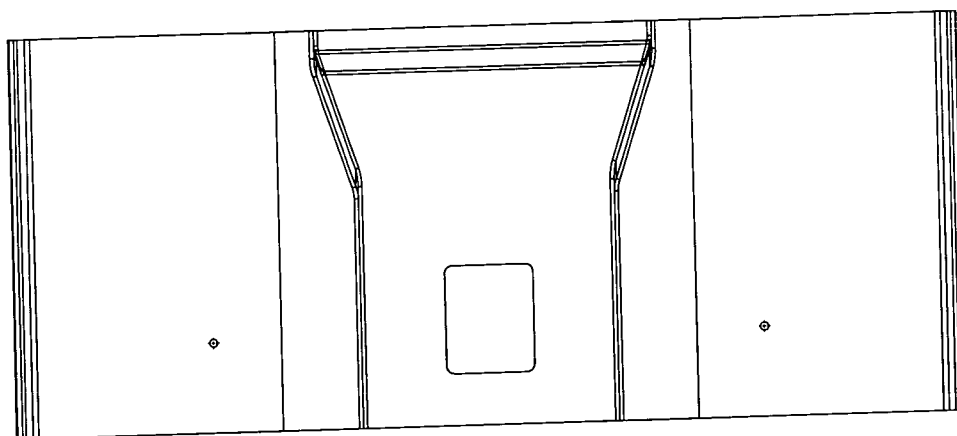
Design Manager Approval: *AWP*

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3656-1	PANEL	07.12.12	N	07.12.13	THERMOFORM PART CONSULT W/ LE FOR TRIMMING	
						INSTALL ONE PART IN AIRCRAFT	
						PULL SECOND PART FOR DEMO <i>N/A.</i>	
						<i>LE</i> <i>07.12.18</i>	

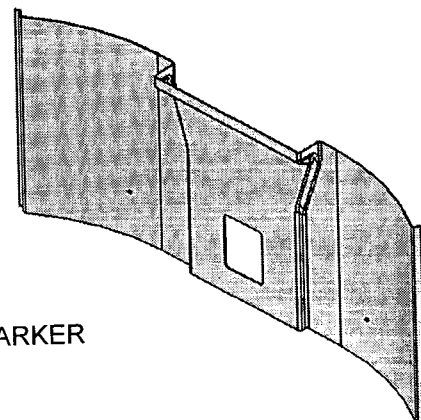
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3656</b>	REV. A SHEET 1 OF 1
DATE <b>07.07.23</b>		TITLE <b>PANEL</b>	SCALE 1:12
REV A	DATE 07.07.23	DESCRIPTION NEW ISSUE	

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
*LE* 07.12.12

*N/O*  
*36315*



**D3656-1 PANEL**  
**(REPLACES EUROCOPTER P/N X)**



**NOTES:**

- 1) MATERIAL: LIGHT GREY F6006 LEXAN SHEET, 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH DART P/N "D3656-1" USING FINE POINT PERMANENT INK MARKER  
ON SMOOTH SIDE OF PART
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) MEASURE PER TEMPLATE DTXXXX

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DART AEROSPACE LTD		Work Order: 31315
Description: PANEL - 350 REAR CANOPY		Part Number: D3656-1
Inspection Dwg: D36561 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓		GAGE	
Shape Definition	✓		VISUAL	
Texture Retention	✓		VISUAL	
Material imperfections such as bumps, cracks, voids, scratching	✓		VISUAL	

Measured by: DL

Date: 07/12/13

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments

Measured by: \_\_\_\_\_

Date: \_\_\_\_\_

Audited by: \_\_\_\_\_

Date: \_\_\_\_\_

Prototype Approval: \_\_\_\_\_

Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	